

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012720**Date Inspected:** 13-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D. Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # SEGMENT 6AW

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 005334 to perform Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Ultrasonic Test report for this date. The member is identified as segment 6AW Bottom Panel to Side Panel Splice Weld. The weld tested is identified as follows:

(CA025-005)

OBG # SEGMENT 6BW

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 005334 to perform Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Ultrasonic Test report for this date. The member is identified as segment 6BW Bottom Panel to Side Panel Splice Weld. The weld tested is identified as follows:

(CA027-001)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG # SEGMENT 6CE

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 005327 to perform Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Magnetic Particle Test report for this date. The member is identified as segment 6CE. The weld tested is identified as follows:

(SSD27-PP45-017,018,019,020,021,022,023,024)
(SSD27-PP45-045,046,049,050,051,052,053,054)
(SSD27-PP45-089,090,091,092,093,094,095,096,097,098)
(SSD27-PP45-123,124,121,122,119,120,113,114)
(SSD27-PP45-165,166,167,168,169,170,172,173,175,176)
(FB028-001-015,016,017,018,128)
(FB032-001-015,016,017,018,128)
(FB036-001-015,016,017,018,128)
(BP025-006-044,053)

This QA Inspector randomly observed the following work in progress:

OBG # CROSS BEAM 17 (BAY 8)

This QA observed ZPMC qualified welding personnel identified as 040831 perform Submerged Arc Weld (SAW) Process on weld joint CB3001D-017-001. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang qiao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

This QA observed ZPMC qualified welding personnel identified as 054459 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3058-054-033. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang qiao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 054460 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3058-053-028. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang qiao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

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| Inspected By: | Sukanthan,Dhanasingh |
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| Quality Assurance Inspector |
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| Reviewed By: | Hall,Steven |
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| QA Reviewer |
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